

Work Order ID 118380

118380

Page 1

Monday, July 21, 2014 2:44:14 PM

Item ID: D4681-3 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Doubler


Start Date: 7/21/14 Start Qty: 8.00 *8*

Required Date: 7/22/14 Req'd Qty: 8.00 *8*

Reference: SCRAPPEP OLD REV.

Cust Item ID:

Customer:

Approvals: Process Plan:  Date: 4-7-21 Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4681	B

105 0.00 DAS 27 9-89 8

105

QC

Quality Control

Memo

PULL FROM STOCK

0.00 4/7/21

D4681-3

B101097 X4

B101098 X4

0.00 DAS 27 9-89 8

115 0.00

115

Small Fab

Small Fab

Memo

SCRAPPED OLD REV. A

0.00 4/7/21

115 0.00

115

Small Fab

Small Fab

Memo

SCRAPPED AND DESTROY

0.00 4/7/21

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Page 2

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Item Name: Doubler
Start Date: 7/21/14 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 7/22/14 Req'd Qty: 8.00 ***8*** Customer:
Reference: SCRAPPEP OLD REV.

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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125

QC21- Final Inspection - Work Order Release

0.00



125

QC

Memo

0.00

Quality Control

14/7/22 
14-7-22

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Equip/Tooling									
Handling/Pre									
Material									
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Offset/Setup									
Process									
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Training									
Transport									
Unapproved									

FAULT CATEGORY

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118380

GRAIN DIRECTION

22.540
24 HOLES @
0.98 SPACING

R0.05
TYP

Ø0.129
TYP

C/L
SYM

3.576

1.310

1.000

0

R0.30
TYP

0.063
REF

27.100

BEND LINE REF

Ø1.000
3 PL

9.567

4.230

3.900

2.487

0

D4681-3F DOUBLER
(FLAT PATTERN)

RELEASE
2013-03-25

NOTES:
1) MATERIAL: 6061-T6/T82 SHEET 0.063 THK PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209 (REF DART SPEC. M6061T6S.063)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.56 lbs

DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	DRAWING NO. D4681	REV. A SHEET 4 OF 4
DRAWN	AP			
CHECKED			TITLE WEB ASSY	SCALE NTS
MFG. APPR.				
APPROVED				
DE APPR.				
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GRAIN DIRECTION

3.576
1.310
1.000
0.063 REF
R0.30 TYP

Ø0.129
TYP

C/L
SYM

—BEND LINE REF

Ø 1.000
3 PL

9.567 -

4.230
3.900

2.487 -

9

D4681-3F DOUBLER
(FLAT PATTERN)

RELEASE
2013-03-29

NOTES:

- 1) MATERIAL: 8061-T6/T62 SHEET 0.063 THK PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209 (REF DART SPEC. M8061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.56 lbs

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DRAWN	AP		SHEET 4 OF 4
CHECKED			
MFG. APPR.			
APPROVED			SCALE
DE APPR.			NTS
DATE	13.02.13		

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